



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4775-041
Job Sheet 180591



Part No: D4775-041

Job Qty: 12 ea

Part Name: Strut Assembly



5093570

Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/10/18

Job Tracking No:

Due Date: 7/20/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C SHEET 1 IPP REV:A 13.02.28 NEW ISSUE DD VERF:JFS IPP REV:B 13.08.26 PB1 DD
VERF:JLM IPP REV:C 13.09.26 AS PER REV.B DD VERF:JLM IPP REV:D 14.01.10 AS PER REV.C DD
VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea	7/20/18	7/20/18	0.00	0.00	Start Up Stores/Pkg-1		JUL 19 2018
110	Packaging	12 pcs	7/20/18	7/20/18	0.00	0.00	Packaging1-5		JUL 19 2018
120	Small Fab	12 pcs	7/20/18	7/20/18	0.00	4.98	Small Fab-7		DAS 38
130	QC	12 pcs	7/20/18	7/20/18	0.00	0.00	QC5		JUL 26 2018
140	Packaging	12 pcs	7/20/18	7/20/18	0.00	0.00	Packaging3-2		JUL 26 2018
150	QC21-SA	12 Ea	7/20/18	7/20/18	0.00	0.00	QC21		JUL 26 2018

Part Op 120 - 1- APPLY PROSEAL ON D4776-1 STRUT AND ASSEMBLE AS PER DWG A/R PROSEAL
Descriptions: BATCH: 138848 2- ENSURE HELICOIL DOES NOT BLOCK HOLE (SEE NOTE 9)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-10A	Bolt	24 Ea (2 ea)	90-Start up Operation	5078257
D4775-1	Strut Tube	12 Ea (1 ea)	90-Start up Operation	5083573
D4776-1	Basket Strut Clevis	12 Ea (1 ea)	90-Start up Operation	5091738
D4776-5	Spacer	48 Ea (4 ea)	90-Start up Operation	5090210
D4777-1	Rod End Bearing	12 Ea (1 ea)	90-Start up Operation	5084079
MS21042L3	Nut	24 Ea (2 ea)	90-Start up Operation	5078167
MS21209-F615	Heli-Coil	12 Ea (1 ea)	90-Start up Operation	5073809

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3-10A	24	329	0
	D4775-1	12	31	0
	D4776-1	12	13	0
	D4776-5	48	108	0
	D4777-1	12	32	0
	MS21042L3	24	2,037	0
	MS21209-F615	12	77	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																		
Large Fab ☐	Composite ☐	Supplier ☐																			
Date : _____	INTV Effective : _____ Container No: S093510 Strut Assembly Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com			MRB (QSI042) Approval																	
Description W/ _____				Completed By																	
				Lead hand / Supervisor Approval Verification																	
				QC / QA Coordinator Approval																	

PART NO: D4775-041

Serial No/Batch: S093510

Revision:

Operation: Packaging

Change No:

Mfg Date: 07/19/18

Job No: 180591

Root Cause			
Environment ☐	No Re-verific ☐		
Design ☐	Operator ☐		
Doc/Data ☐	Offset/Setu ☐		
Equip/Tooling ☐	Supplier ☐		
Handling/Pre ☐	Training ☐		
Material ☐	Use for Testing ☐		
Internal Transport ☐	Poor Information ☐		
Tribal Knowledge ☐	Rushing ☐		
LOA ☐	Product Improvement ☐		
Substation ☐	Process Improvement ☐		
Past Expiry Date ☐	Manufacturing Process ☐		
Misidentified ☐	Past Due ☐		

	Cracks ☐		Inspection Incomplete/Unqualified ☐		Pulled ☐
	Crimp/Kink/Ripple/Wave ☐		Contamination ☐		Out of Sequence ☐
	Cuffs ☐		Countersink ☐		Off-set ☐
	Crushing ☐		Cut Too Short ☐		Mislabeled ☐
	Heat Treat ☐		Instructions Incomplete/Unclear ☐		Fit/Function ☐
	Wave/Twist in Tube ☐		Drill Holes ☐		Misaligned/off center ☐
	Marks/Chatter ☐				

Positioned Wrong ☐

Outside Dimensions ☐

Over/Under tolerance ☐

Part Incorrect ☐

Part Lost/Missing ☐

Part Moved ☐

Drawing ☐

Finish ☐

Misread ☐

Turning Sequence ☐

OTHER :